


Date: Thursday, 7/19/2007 2:21:05 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD TUBE ASSEMBLY
Job Number	: 33633		
Estimate Number	: 10467		
P.O. Number	: N/A	Part Number	: D3391021
This Issue	: 7/19/2007 S.O. No. : N/A	Drawing Number	: D3391 REV.F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: F
Previous Run	: 33632	Material	: N/A
Written By	:	Due Date	: 7/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>7/19/07</u>		
Comment	: Est. A 05.09.13 New issue KJ/JLM		
	: Est. B 06.02.10 Dwg rev.D ecn 773 EC		
	: Est. C 06.05.02 Added inspections EC		
	: est D 07.03.13 rev F dwg EC		

## Additional Product

Job Number: 

Seq. #: Machine Or Operation: Description :

1.0 D6013047 SKIDTUBE MAT'L



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 SKIDTUBE MAT'L

Pick:

Qty	Part Number	Description	Batch
1	D6013-047	Extrusion	B26547 DP 7-7-25

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1  
 Cut extrusion to 46.52 +0.010 -0.020

DP 7-7-25

3.0 BENDING BENDING MACHINE



Comment: Nc bender  
 Bend as per Dwg D3391 Using Bend Prog 3391021

EL 7-10-31

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/11/07

5.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
 1-Machine as per Folio FA590 Rev. F & Dwg D3391 Rev. F  
 Identify as D3391-1

2-Deburr

SD 07.11.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:21:05 PM

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## Process Sheet

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Drawing Name: FWD TUBE ASSEMBLY

Job Number: 33633

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 07.11.04

7.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill X1 Aft cap as per Dwg D3391

J. 07.11.04

①

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J. 07.11.04/①

9.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SL 07/11/05

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill and c/sink float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)  
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5-Deburr & Scribe Batch number Inside aft end.

JP  
7-11-15

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

J. 11.15.0

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SL 7-11-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: FWD TUBE ASSEMBLY

Job Number: 33633

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(IX)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 07/11/15

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FD 07/11/16 (1)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(IX)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 07/11/16

16.0

NAS1330C3KB166

INSERT



NAS1330S3KB166



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Rivnut

Pick:

Qty

Part Number

Description

Batch

14

NAS1330C3KB166

Insert

M 107819

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(IX)

Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg

M-1 07/11/16

18.0

QC5

INSPECT WORK TO CURRENT STEP



(1)

Comment: INSPECT WORK TO CURRENT STEP

M 07/11/16

19.0

D3401041

Tow Cap Assembly



(IX)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tow Cap Assembly

Pick:

Qty

Part Number

Description

Batch

1

D3401-041

Tow Cap

B 26881

07/11/16

M-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:21:05 PM  
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Drawing Name: FWD TUBE ASSEMBLY

Job Number: 33633

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D356413

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
WEARSHOE

B 33867

M-J

21.0

D356613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
GASKET

B 32744

M-J

22.0

AN3C4A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)  
Bolt  
Pick:  
Qty Part Number Description Batch  
4 AN3C4A Bolt

M106043

M-J

23.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Washer  
Pick:  
Qty Part Number Description Batch  
4 NAS1515H3L Washer

M105116

M-J

24.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)  
washer

M106242

M-J

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Install tow Cap as per Dwg D3391  
Identify as D3391-021

M-J

07/11/16

(1X)

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP  
Inspect thread of each insert using DT8821

M 07 11 16

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 21/11/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Drawing Name: FWD TUBE ASSEMBLY

Job Number: 33633

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

35248

28.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Don 15

Job Completion



W 07.11.07

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

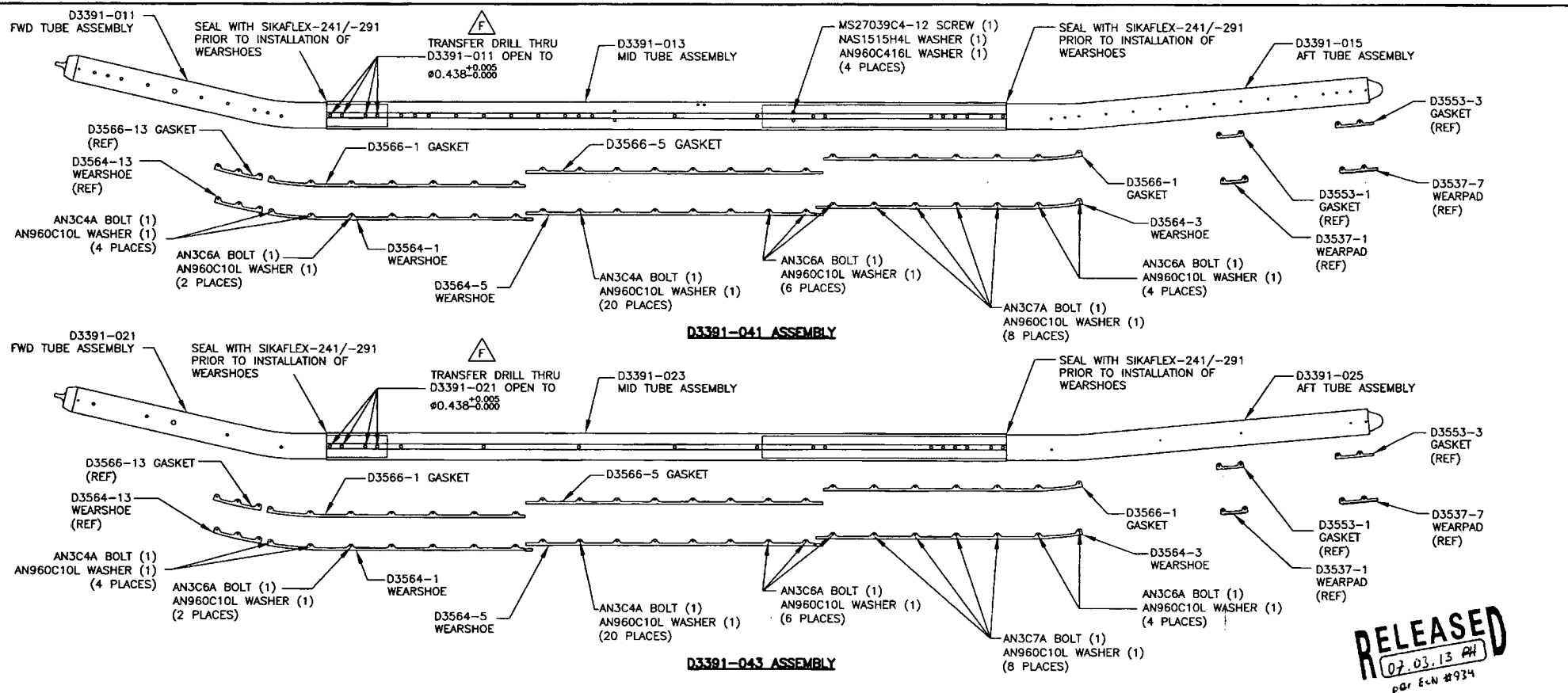
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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





# D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
1	1	D3391-021	FWD TUBE ASSEMBLY
1	1	D3391-023	MID TUBE ASSEMBLY
1	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
1	1	D3564-5	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4	4	MS27039C4-12	SCREW
4	4	NAS1515H4L	WASHER
4	4	AN960C416L	WASHER

## GENERAL NOTES

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALDINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (0.250-0.257) FOR WEARSHOE INSERTS. C/SINK 0.391/0.425 x 100' AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

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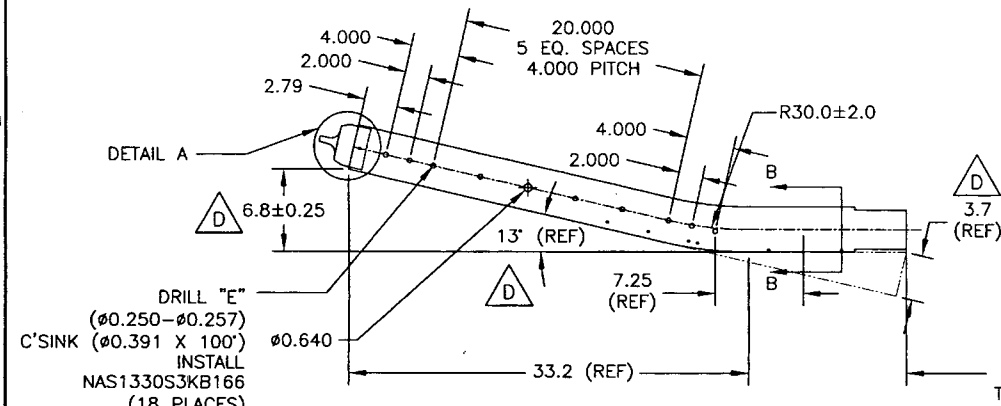
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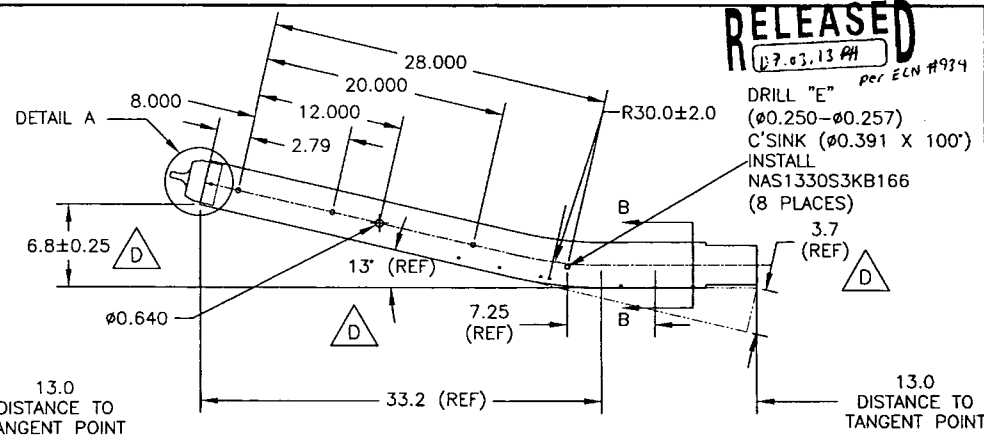
F	07.01.18	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021
E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3391
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	REV. F SHEET 1 OF 5 SCALE NTS

**RELEASED**  
17.03.13 AH

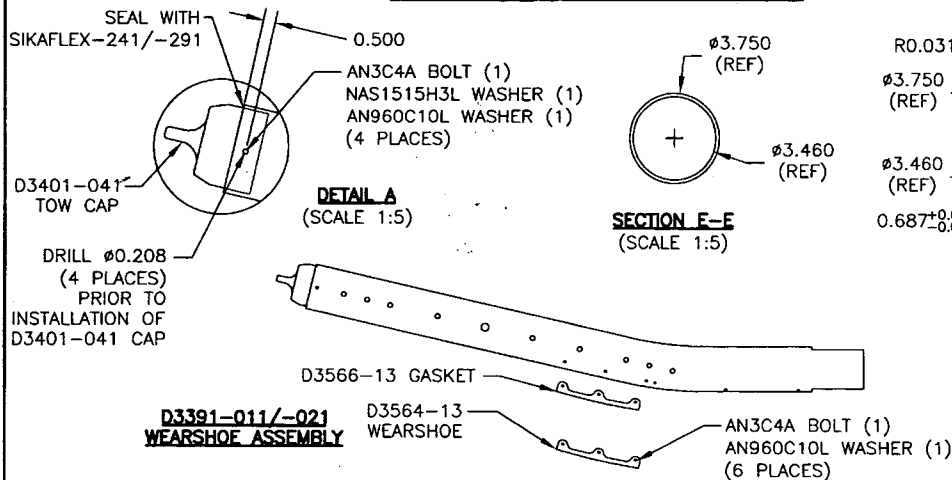
per ELN #934



**D3391-011 ASSEMBLY AND BENDING DETAIL**



**D3391-021 ASSEMBLY AND BENDING DETAIL**

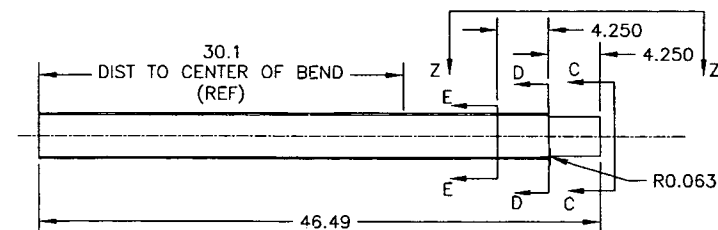


**D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST**

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
		D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
10	10	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER
30	20	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)

5  
DRILL "E"  
(Ø0.250-Ø0.257)  
C'SINK (Ø0.391 X 100')  
INSTALL  
NAS1330S3KB166  
(12 PLACES)

**SECTION B-B**  
(SCALE 1:5)



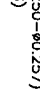
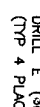
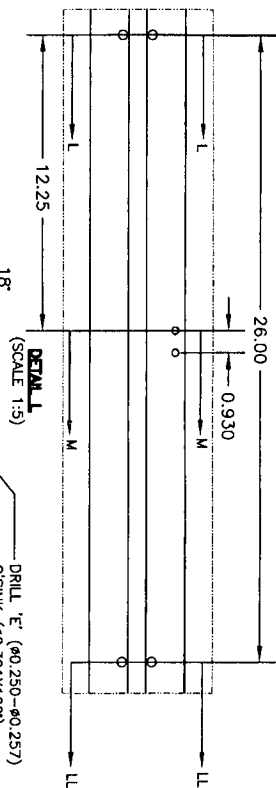
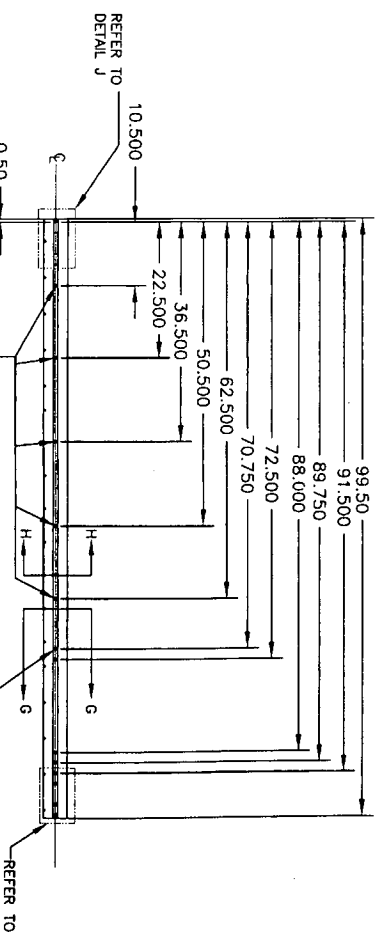
**D3391-1 DRILLING AND CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

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CHECKED	APPROVED	DRAWING NO.	REV. F
		D3391	SHEET 2 OF 5
DATE		TITLE	SCALE
07.01.18		412 FLOAT SKIDTUBE	1:10

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33033

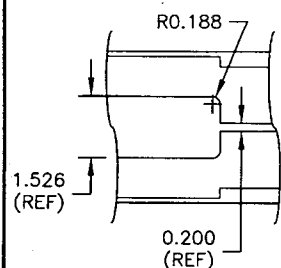


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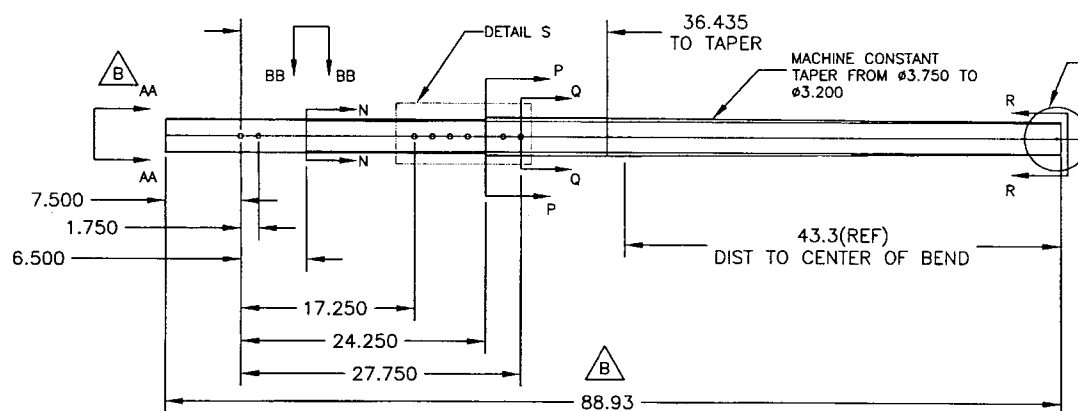
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CHECKED 		APPROVED 		DRAWING NO. D3391		REV. F SHEET 3 OF 5	
DATE 07.01.18				TITLE 412 FLOAT SKID/TUBE		SCALE 1:20	

**D3391-023 ASSEMBLY DETAIL**

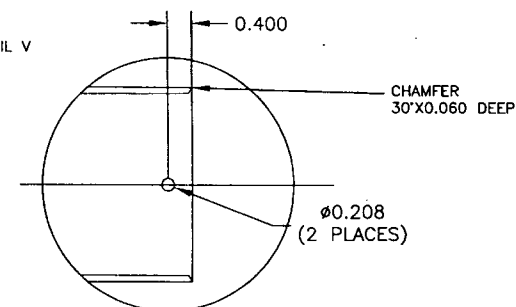
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07.05.13 PM  
DOE ECU #934



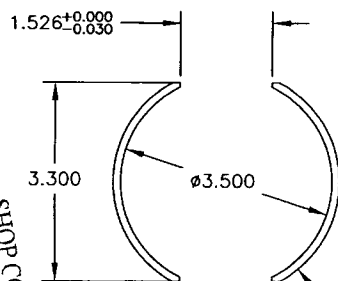
VIEW BB-BB  
(SCALE 1:3)



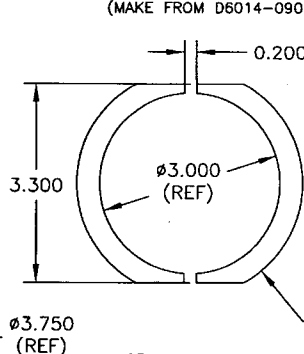
D3391-3 AFT DRILLING AND CUTTING DETAIL  
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



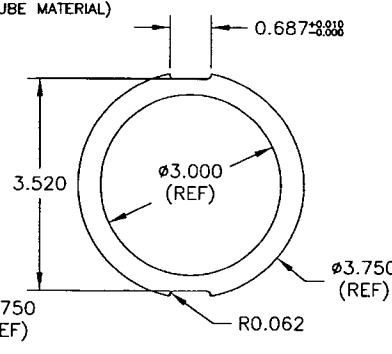
DETAIL V  
(SCALE 1:2)



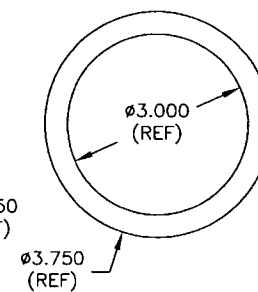
SECTION AA-AA  
(SCALE 1:2)



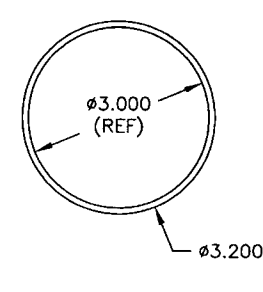
SECTION N-N  
(SCALE 1:2)



SECTION P-P  
(SCALE 1:2)

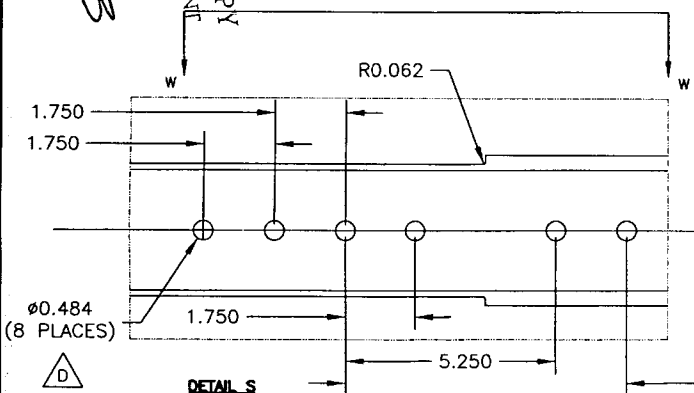


SECTION Q-Q  
(SCALE 1:2)

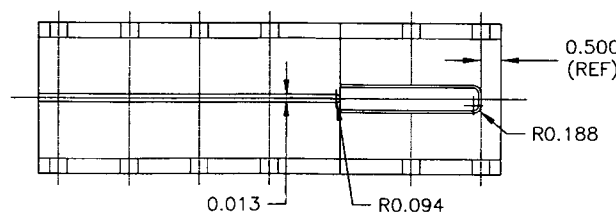


SECTION R-R  
(SCALE 1:2)

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DETAIL S  
(SCALE 1:3)



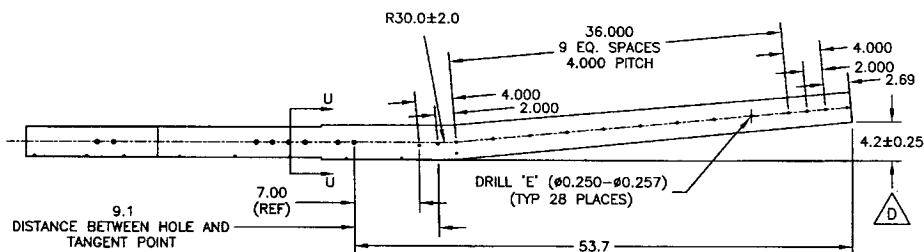
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RELEASED  
 07-03-13 PH  
 per ECU #934

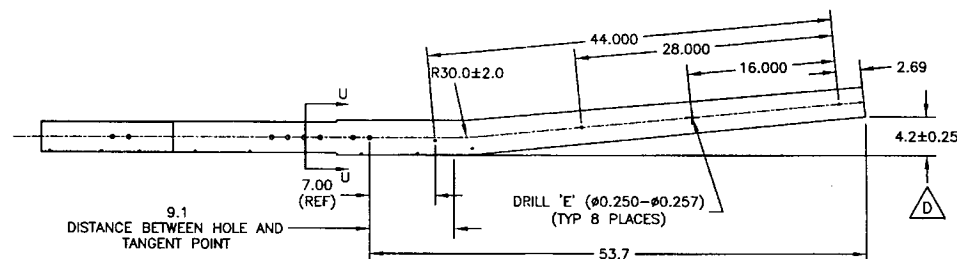
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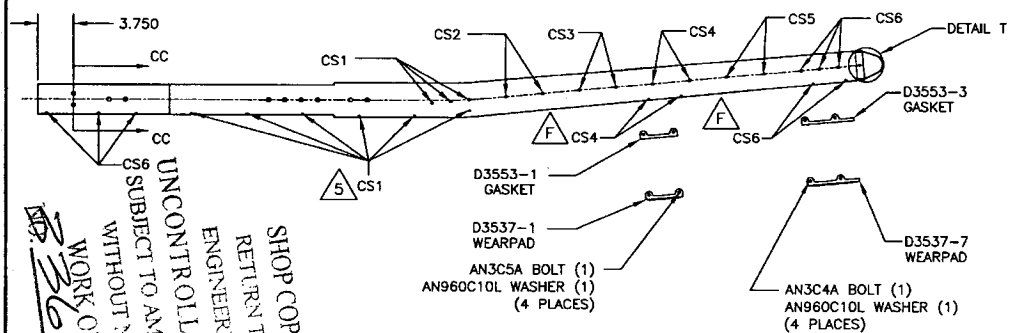
DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. F
CHECKED #	APPROVED #	DRAWING NO. D3391	SHEET 4 OF 5
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SCALE 1:12	



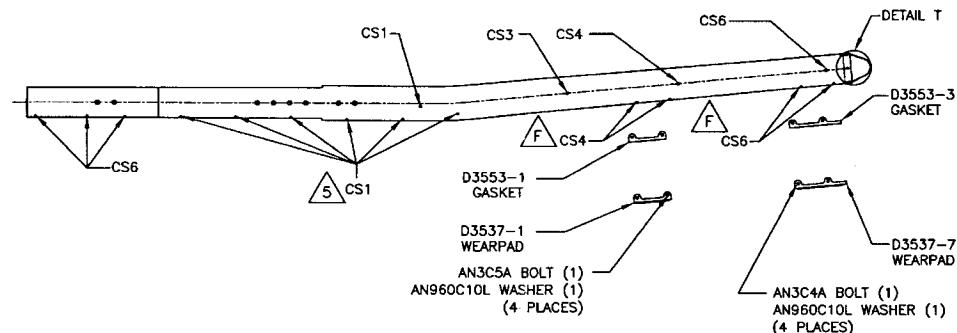
D3391-015 BENDING AND ASSEMBLY DETAIL



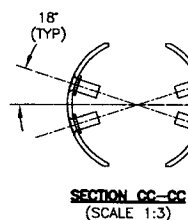
D3391-025 BENDING AND ASSEMBLY DETAIL



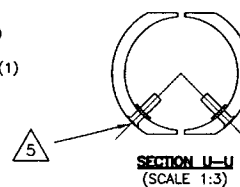
D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL (SEE TABLE)



D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL (SEE TABLE)



DRILL 'Q' (Ø0.332-Ø0.338)  
C'SINK (Ø0.529X100")  
NAS1330S4KB151 INSERT (1)  
(4 PLACES)



AN3C4A BOLT (1)  
NAS1515H3L WASHER (1)  
AN960C10L WASHER (1)  
(2 PLACES)  
DETAIL T (SCALE 1:3)  
D2646 AFT CAP  
SEAL WITH SIKAFLEX-241/-291

RELEASED  
07.03.13 RH  
per EGN #934

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4		NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER

C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4		Ø0.391	NAS1330S3KB366
CS3	4	2	Ø0.391	NAS1330S3KB316
CS4	8	6	Ø0.391	NAS1330S3KB266
CS5	4		Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166

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DESIGN RH	DRAWN BY RH	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, MA	REV. F
CHECKED H	APPROVED H	DRAWING NO. D3391	SHEET 5 OF 5
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SCALE 1:12	